

Date: Wednesday, 12/12/2007 11:36:54 AM  
 User: Kim Johnston

## Process Sheet

(20)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 36274  
 Estimate Number : 11704  
 P.O. Number : N/A Part Number : D2725  
 This Issue : 12/12/2007 S.O. No. : N/A Drawing Number : D2725 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 12/12/2007 Type : SMALL /MED FAB Drawing Revision : C  
 Previous Run : 30882 Material : N/A  
 Due Date : 12/21/2007 Qty: 201 Um: Each  
 Written By :  
 Checked & Approved By : JA 07.12.12  
 Comment : Est. D 99.02.11 Added 4 per Blank  
 Est Rev:E Now on Waterjet 06-10-15 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



M6061T6S188

37.752



Comment: Qty.: 0.1815 f(s)/Unit Total: 36.4905 f(s)  
 6061-T6 Bar .188" x 4.0"

Material: 6061-T6 (QQ-A-250/11) 4" x 0.188" Thick

Batch: 103386 IB 07-12-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2725

Dwg Rev: C

Prog Rev: C

IB 07-12-12

2-Deburr if necessary

CP 08/01/03 (208)

(208)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



QSP 012



Comment: SECOND CHECK

08/01/03

(208) counts

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 23

08.01.09 208

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: HD Date: 08/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 12/12/2007 11:36:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 36274

Part Number: D2725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



208

Comment: FINAL INSPECTION/W/O RELEASE

D20810/11

Job Completion



mi 2008/1/10

U

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

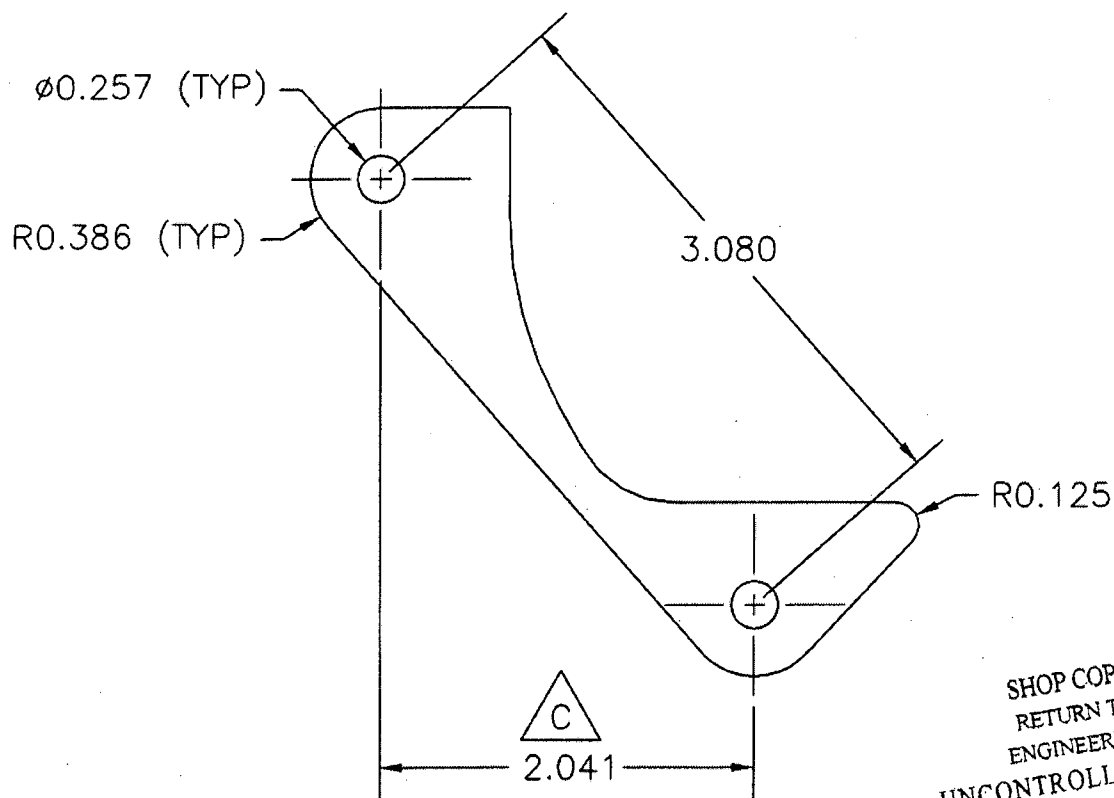
NOTE: Date & initial all entries





|                       |                       |   |                        |
|-----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>KE</i>   | DRAWN BY<br><i>KE</i> | DART AEROSPACE USA, INC.<br>FAIRCHILD INTERNATIONAL AIRPORT, WA |                        |
| CHECKED<br><i>MAA</i> | APPROVED<br><i>KS</i> | DRAWING NO.<br>D2725  | REV. C<br>SHEET 1 OF 1 |
| DATE<br>98.10.19      |                       | TITLE<br>STEP MOUNTING PLATE                                    | SCALE<br>1:1           |
| A                     | 97.12.04              | NEW ISSUE   |                        |
| B                     | 98.05.04              | 0.188 THICK WAS 0.125   |                        |
| C                     | 98.10.19              | REVISED GEOMETRY FOR 5.5° STEP ANG.                             |                        |

RELEASED  
14.11.11 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36274

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

